

Work Order ID 70543

Friday, June 10, 2011 2:57:50 PM



Page 1

Item ID:	D2842-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly RH, 206 Float					
Start Date:	6/10/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	6/15/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-06-13	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2842	Rev B								
100	Large Fab	0.00							
	Large Fab	0.00							
Large Fab	Memo								
	1-Cut D2842-1 using D2622 extrusion as per Dwg D2842								
	2-Drill D2842-1 using Jig DT8272 as per Dwg D2842								
	3-Deburr and bevel ends for welding								
105	QC6- Inspect dimensions to drawing	0.00							
	QC	0.00							
Quality Control	Memo								
110	Weld per dwg A/R Aluminum rod Batch: 114703	0.00							
	Large Fab	0.00							
Large Fab	Memo								
	1-Weld one end cap and (2) lugs as per Dwg D2842								
	2-Grind end cap weld flush								

Handwritten: A.E 11-06-14 (x2) 2

Handwritten: 11-06-15

Handwritten: 11-06-16 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

2 0 BE11/06/17

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S w/06/17

Y2
RH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

K/A.E H-06-17-

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 114703 Large Fab Memo 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.	0.00 0.00				11.06.20	2		
170 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				11.06.20			

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

8 uloc(2)

22
RH

Memo

185



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

Memo

Touch up step with alodine per qsi 005 prior to powder coat

2X ~~Ø~~ m-11/06/22
RH

190



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:45
320°F
1:152X ~~Ø~~ m-11/06/22
RH

M116964

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BK 11-6-23.

210

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D2842
2-Wing Walk as per Dwg D2842 and QSI 005 4.1
Batch: 117863.

2 BK 11-6-23.

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 w/06/23



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Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP70540

0.00

Packaging

11/6/27 (2)

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/27

MF
11-06-27

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Picklist Print

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Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960C10L	NAS1149C0332 R	Purchased	No			100	Each	0.0000	3	6			
-----------	-------------------	-----------	----	--	--	-----	------	--------	---	---	--	--	--

117887



washer

D2622-120C

Manufactured No

110

Each

35.7000

1

2



Step Extrusion

Location

Loc Qty

Loc Code

HALL

6

64409

6

WA

29.7

46910

2

66970

27.7

D2734

Manufactured No

110

Each

48.0000

2



Step End Plate

Location

Loc Qty

Loc Code

WA

45

69537

45

WA015

3

66143

3

D3459-1

Manufactured No

110

Each

23.0000

2

4



Float Step Mounting Plate

Location

Loc Qty

Loc Code

WA017

23

62955

23



6 BR 11-6-23



A.E 11-06-14



2 11-06-16



11-06-16

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 70543



Parent Item: D2842-042



Parent Item Name: Step Assembly RH, 206 Float

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

D3459-3 Manufactured No

210

Each

29.0000

2

4



Float Step Mounting Plate



11-06-16

Location

Loc Qty

Loc Code

ST017

29

62956

29

4

MS27039C1-07

Purchased

No

210

Each

65.0000

3

6



screw



Location

Loc Qty

Loc Code

ST293

65

117423 ✓

65

6

BR 11-6-23.

NAS1329C3KB130

Purchased

No

210

Each

64.0000

3

6



insert



Location

Loc Qty

Loc Code

FP-A

14

115719 ✓

14

6

BR 11-6-23.

ST276

50

117679

50

6

NAS1515H3L

Purchased

No

210

Each

268.0000

3

6



WASHER



Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

228

113362 ✓

228

6

BR 11-6-23.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

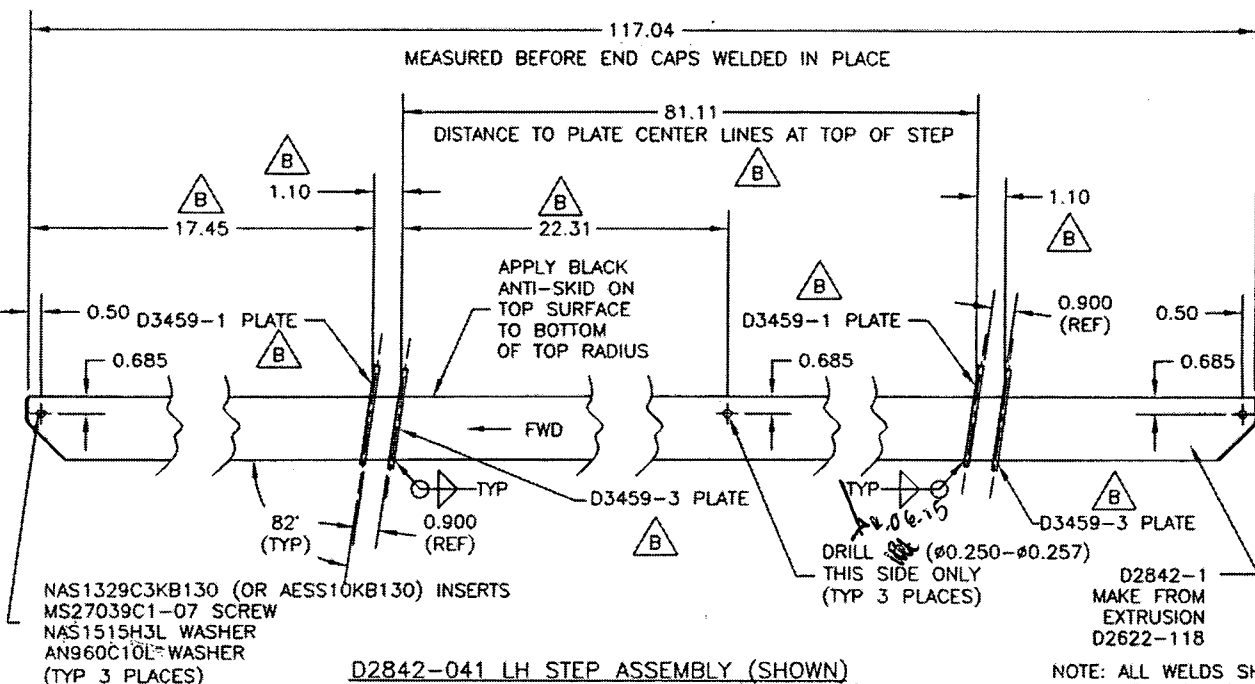
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D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	-041	D2842-041	LH STEP ASSEMBLY
X	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

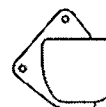
D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3.
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 70543

REFER TO STEP
END DETAIL



DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23	05.09.23	206L/407 FLOAT STEP ASSEMBLY
A	98.10.13	NEW ISSUE
B	05.09.23	RE-DESIGN, ADD D3459-1/-3
		SHEET 1 OF 1
		SCALE

RELEASED
5/1/14

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